

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020245**Date Inspected:** 31-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**OBG TRIAL ASSEMBLY****OBG Segment 12AE+12BE Repair Welding**

This QA Inspector observed ZPMC qualified welding personnel identified as 044515, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE+12BE Side plate to Side plate joint. Joint identified as OBE12D-003. ZPMC QC Identified as Wang Li Yang with temporary welding repair report WRR-B-WR19715. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) FCM-Repair-1. For more information see below attached picture number 1.

**OBG Segment 12AE+12BE Repair Welding**

This QA Inspector observed ZPMC qualified welding personnel identified as 044515, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE+12BE Side plate to Side plate joint. Joint identified as CA6502-008. ZPMC QC Identified as Wang Li Yang with temporary welding repair report WRR-B-WR19715. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) FCM-Repair-1.

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## WELDING INSPECTION REPORT

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### OBG Segment 12AW+12BW Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040611, 046704 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW+12BW Bottom plate to Bottom plate joint Repair welding. Joint identified as OBW12B-001. ZPMC CWI Identified as Zhu Zhong Hai with temporary welding repair report WRR-B-WR19714. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. For more information see below attached picture number 2.

### OBG Segment 12AE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040270 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE Deck plate 'I' Rib, weld build up on Edge of I ribs Cross beam side. ZPMC QC Identified as Wang Li Yang with Temporary welding repair report WWR-B-WR19617. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair-1. For more information see below attached picture number 3.

### OBG Segment 12BE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12BE Deck plate to Edge plate joint Repair welding. Joint identified as CA3003-002. ZPMC QC Identified as Wang Li Yang with temporary welding repair report WRR-B-WR19716. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

### OBG Segment 12AW Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040656 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW Deck plate to Edge plate joint Repair welding. Joint identified as CA3006-002. ZPMC CWI Identified as Zhou Peng with Critical welding repair report CWR-B-CWR2510. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

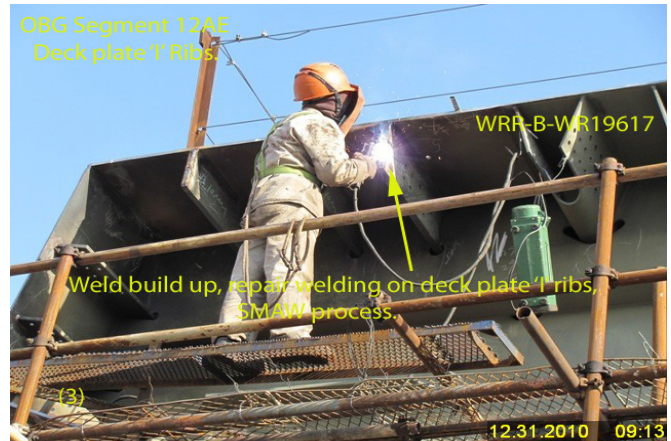
Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone :150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer